Work Order ID 80557 *80557*

February-23-12 9:20:16 AM

Item ID: D2809 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bushing

Start Date: 2/23/12 **Start Qty:** 60.00 *60* **Cust Item ID:**

Required Date: 2/24/12 **Req'd Qty:** 60.00 *60* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** W **Date:** **Tooling:** **Date:**

Stop *NR2*

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2809	**Revision Nbr** Rev A1									
100 *100* Hardinge Hardinge CNC Lathe Small	Hardinge CNC LATHE SMALL **Memo** Machine as per Folio FA204	0.00 0.00	[signature] 12/02/24				65	—		
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00	[signature] 12/02/24				65	—		
120 *120* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00	SL 12-02-24							

Work Order ID 80557

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80557

Item ID: D2809	**Accept** *N900040100*	**Setup**	**Start** *NS1*
Revision ID:			**Stop** *NS2*
Item Name: Bushing			
Start Date: 2/23/12	**Start Qty:** 60.00 *60*	**Cust Item ID:**	
Required Date: 2/24/12	**Req'd Qty:** 60.00 *60*	**Customer:**	
Reference:			

Approvals:	**Process Plan:**	**Date:**	**Tooling:**	**Date:**	**Run** **Start** *NR1*
	QC:	**Date:**	**SPC (Y/N):**	**Date:**	**Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				63 ✗			M 12/02/28
M120222	Memo START TIME: 11:50 OVEN TEMPERATURE: 320°F FINISH TIME: 12:20	0.00							
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				AB			12-2-27 (63)
	Memo	0.00							
160 *160* QC Quality Control	QC3- Inspect Part Finish	0.00				63 count ✓			M 12/02/28
	Memo	0.00							

Work Order ID 80557

February-23-12 9:20:16 AM

80557

Item ID:	D2809	**Accept**	*N900040100*
Revision ID:			
Item Name:	Bushing		

Setup **Start** *NS1*

Stop *NS2*

Start Date:	2/23/12	**Start Qty:**	60.00	*60*
Required Date:	2/24/12	**Req'd Qty:**	60.00	*60*
Reference:				

Cust Item ID:

Customer:

Approvals:	**Process Plan:**	**Date:**	**Tooling:**	**Date:**
	QC:	**Date:**	**SPC (Y/N):**	**Date:**

Run **Start** *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* Packaging	Identify as per dwg & Stock Location: G.A	0.00				12/02/28			63
Packaging	**Memo**	0.00							
180 *180* QC	QC21- Final Inspection - Work Order Release	0.00				12/2/29			
Quality Control	**Memo**	0.00							

12-02-28

Picklist Print

February-23-12 9:20:16 AM

Work Order ID: **80557**

Parent Item: **D2809**

Parent Item Name: Bushing

Start Date: 2/23/12 **Required Date:** 2/24/12

Start Qty: 60.00 **Required Qty:** 60.00

Comments: IPP C02.03.07Now turned in houseNG IPP REV:D 11.12.08 added powdercoat per dwg DD VERF:EC

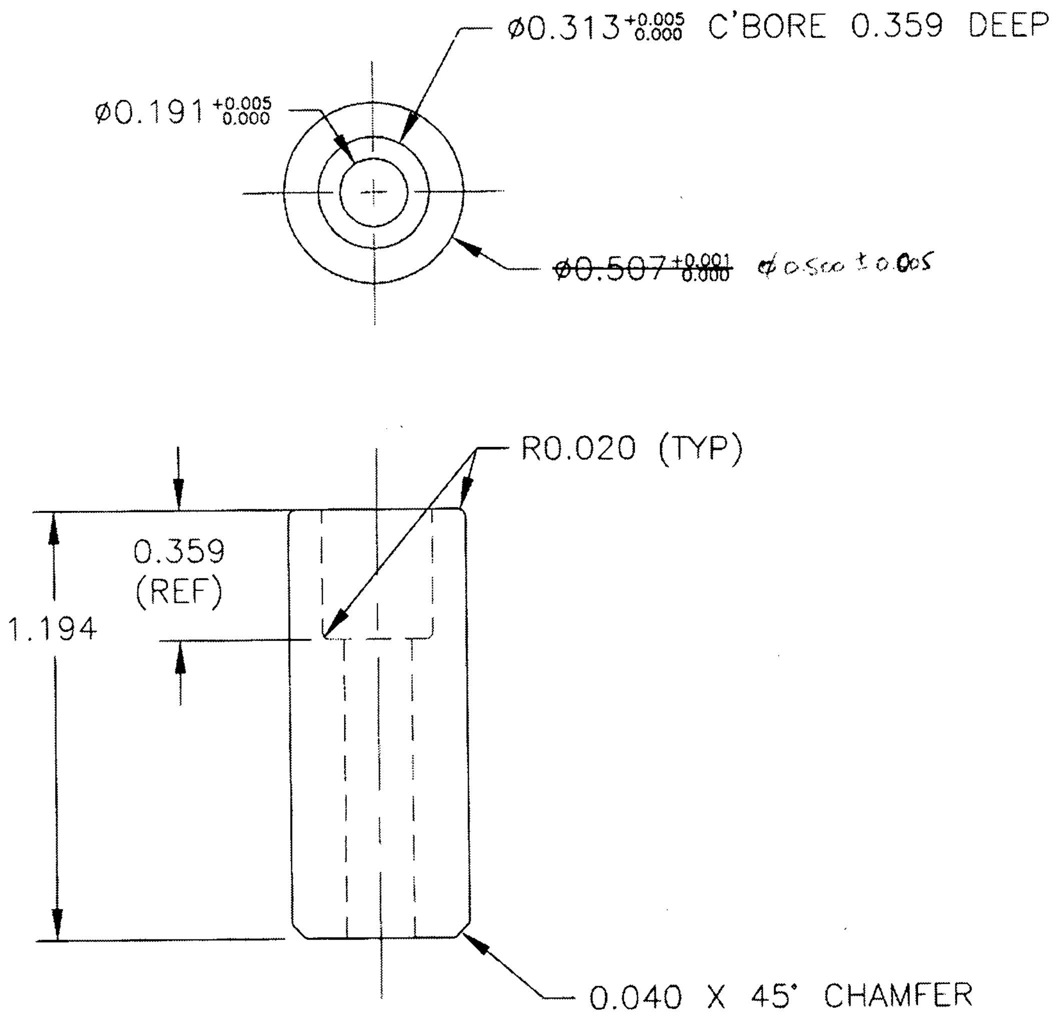
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500 6061-T6 Round Bar .500"		Purchased	No			100	f	159.0080	**0.0995**	**6.2842105**			

Location		Loc Qty	Loc Code	
MAT012		159.008		
	114488	1.997		
	117379	9.288		
	119043	147.723		6.5

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2809	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	01 04 26	ADD POWDER COAT; Ø0.500 WAS Ø0.507	

COPY ISSUED QA

RELEASED 00.11.13



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) — FOR DART QSI 005 4.3

DART AEROSPACE LTD	Work Order:	80557
Description: Spacer	Part Number:	D2809
Inspection Dwg: D2809 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.000	.194	✓		Dial Caliper	BG 05
Ø0.313	+0.005/-0.000	.313	✓			↓
Ø0.500	+/-0.005	.501	✓			↓
0.359	+/-0.010	.360	✓			↓
1.194	+/-0.010	1.194	✓			↓
0.040 x 45°	+/-0.010	.04	✓			↓
R0.020	+/-0.010	.015	✓			↓

Measured by:	[signature] / BG
Date:	12/02/24

Audited by:	[signature]
Date:	12-02-24

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM [signature]	[signature]